

Work Order ID 72937

Thursday, August 18, 2011 1:39:07 PM



Page 1

Item ID: D2574

Accept



Setup Start



Revision ID:

Item Name: Saddle, Aft In 205

Stop



Start Date: 8/18/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 9/5/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 8/18/11

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2574

Rev E

100

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS I

Memo

0.00

HAAS CNC vertical machine #1

Program Batch No. 72937 Double check by: [Signature] 11-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and insp

12

0

110

0.00



CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

Machine keyway as per dwg D2573 & D2574

FK RF 11-8-29

12

0

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

FK RF 11-8-29

12

0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 72937

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Item ID: D2574

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle, Aft In 205

Start Date: 8/18/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 9/5/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

B.A 11/09/02

12

φ

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

12Xφ m-l 11/09/06

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

11:00

11:30

320°F

12Xφ m-l 11/09/06

M117745

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 72937

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Item ID: D2574

Accept



Setup Start



Revision ID:

Item Name: Saddle, Aft In 205

Stop



Start Date: 8/18/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 9/5/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

12 of 11 w/08/6

170

Identify as per dwg & Stock Location ~~ST 434~~

0.00



Packaging

Memo

0.00

Packaging

12x

Sp 11-09-06

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/9/11

MF 11-09-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, August 18, 2011 1:39:13 PM

Page 1

Work Order ID: 72937



Parent Item: D2574



Parent Item Name: Saddle, Aft In 205


Start Date: 8/18/2011

Required Date: 9/5/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev: I As Per RevE 06-01-27 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-005  Saddle Billet		Manufactured	No			110	Each	47.0000	1	12			



✓✓K. 11/09/01

Location	Loc Qty	Loc Code
MAT	14	
71721	14	
MAT045	10	
70677	10	
MAT046	23	
66966	3	
• 72227	20	

12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	72937
Description: Saddle, Aft Inboard	Part Number:	D2574
Inspection Dwg: D2574 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		.440	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.501	3.501	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.004	8.002	8.001	8.002		
F	0.490	0.510		.502	.503	.502	.503		
G	0.257	0.262		.257	.257	.258	.258		
H	0.375	0.380		.375	.375	.375	.375		
I	0.490	0.510		.501	.501	.501	.501		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.566	.566	.568	.566		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		.125	.124	.125	.125		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.250	.250	.250	.250		
S	0.115	0.135		.125	.125	.124	.125		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.232	3.232	3.232	3.232		
V	0.230	0.250		.240	.240	.238	.238		
W	0.115	0.135		.125	.125	.127	.125		
X	0.307	0.312		.311	.311	.310	.310		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.362	.362	.366	.366		
AA	0.470	0.530		.50	.50	.50	.50		
AB	0.615	0.635		.629	.629	.629	.629		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.240	.260	.249	.246		
AE	1.500	1.520		1.512	1.513	1.513	1.512		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.260	.260	.260	.260		
AH	0.240	0.260		.250	.250	.250	.250		
AI	2.000	2.020		2.002	1.998	2.002	2.002		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by: <i>RF / EK</i>
Date: <i>11-8-27</i>

Audited by: <i>MA</i>
Date: <i>11/09/02</i>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD		Work Order:	72937
Description: Saddle, Aft Inboard		Part Number:	D2574
Inspection Dwg: D2574 Rev. E		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				5 X	6 X	7 X	8 X		
A	0.438	0.443		.440	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.501	3.501	3.501	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.003	8.003	8.003	8.001		
F	0.490	0.510		.503	.503	.503	.502		
G	0.257	0.262		.257	.257	.257	.257		
H	0.375	0.380		.375	.375	.375	.375		
I	0.490	0.510		.501	.501	.501	.503		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.566	.566	.566	.568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		.125	.125	.125	.125		
Q	0.115	0.135		.135	.125	.125	.135		
R	0.240	0.260		.250	.250	.250	.250		
S	0.115	0.135		.125	.125	.125	.125		
T	0.178	0.198		.185	.185	.185	.188		
U	3.210	3.250		3.232	3.232	3.232	3.232		
V	0.230	0.250		.240	.240	.240	.240		
W	0.115	0.135		.125	.125	.125	.125		
X	0.307	0.312		.310	.310	.310	.310		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.362	.362	.362	.362		
AA	0.470	0.530		.50	.50	.50	.50		
AB	0.615	0.635		.629	.629	.629	.629		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.260	.260	.260	.250		
AE	1.500	1.520		1.512	1.513	1.511	1.511		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.260	.260	.260	.260		
AH	0.240	0.260		.250	.250	.250	.250		
AI	2.000	2.020		2.003	2.004	2.003	2.003		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	FK, 122
Date:	11/09/01

Audited by:	J.A
Date:	11/09/02

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD		Work Order:	72937
Description: Saddle, Aft Inboard		Part Number:	D2574
Inspection Dwg: D2574 Rev. E		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	9	10	11	12		
A	0.438	0.443		.440	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.002	8.001	8.001	8.001		
F	0.490	0.510		.502	.502	.502	.500		
G	0.257	0.262		.258	.258	.258	.258		
H	0.375	0.380		.375	.375	.375	.375		
I	0.490	0.510		.501	.501	.501	.502		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.568	.566	.568	.568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		.125	.125	.126	.126		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.251	.250	.250	.251		
S	0.115	0.135		.125	.125	.123	.125		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		.240	.239	.238	.238		
W	0.115	0.135		.126	.129	.128	.127		
X	0.307	0.312		.310	.310	.310	.310		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.368	.368	.368	.368		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.626	.628	.626	.626		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.248	.249	.248		
AE	1.500	1.520		1.512	1.512	1.512	1.513		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.260	.260	.260	.260		
AH	0.240	0.260		.249	.249	.249	.249		
AI	2.000	2.020		2.003	2.003	2.004	2.003		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	FK
Date:	11/09/01

Audited by:	B.A
Date:	11/09/02

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

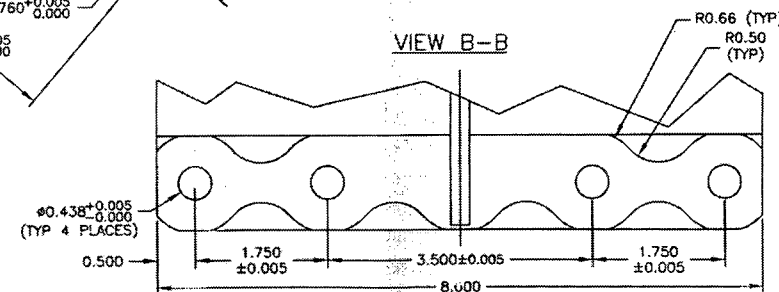
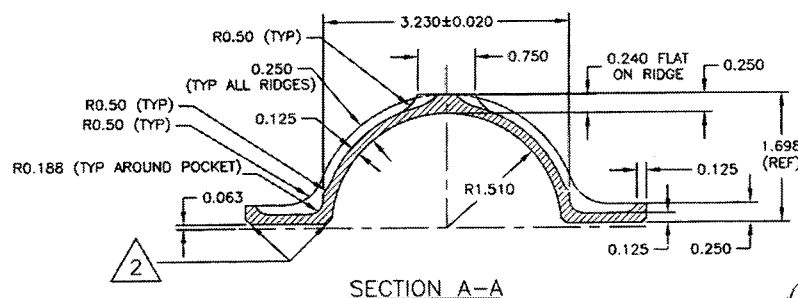
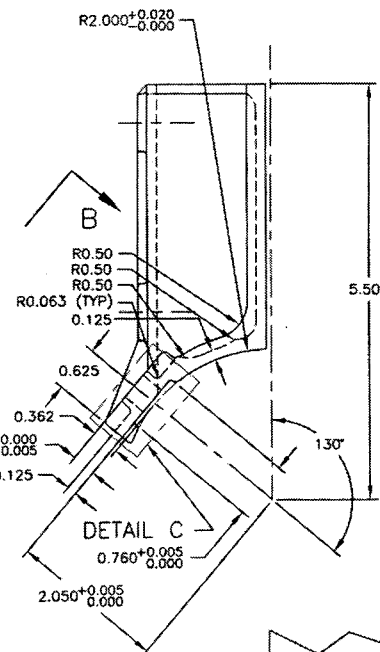
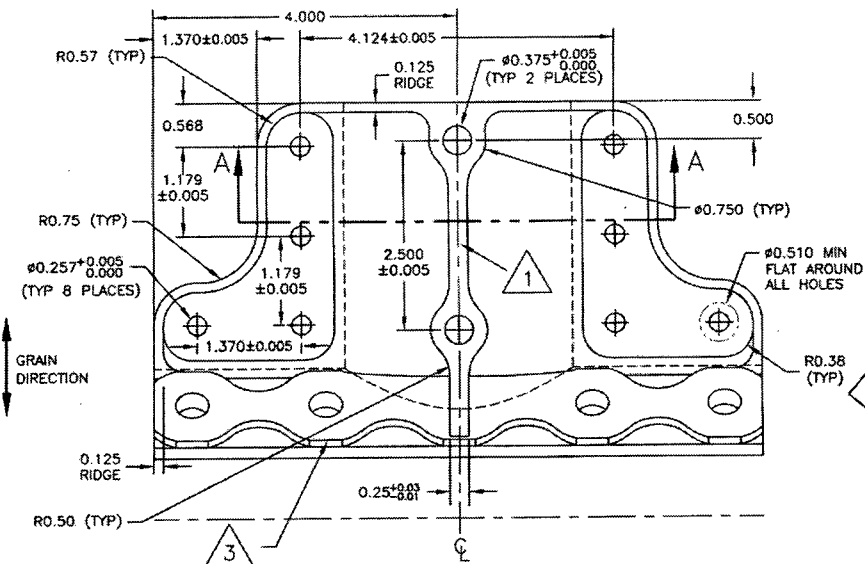
RELEASED

05.12.06

NOTES

MATERIAL: 7075-T7351 (QC-A-250/12)
 (REF DART SPEC. D6102-003)
 FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
 POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
 DART QSI 005 4.3
 BREAK ALL SHARP EDGES 0.010 TO 0.020
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
 2 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
 3 CHAMFER 0.063 x 45° ALL AROUND
 4 CHAMFER 0.033 x 45° (SEE DETAIL C) E



DETAIL C
 SCALE 2:1

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE

WORK ORDER
 NO. 72737

11-08-18

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 PERSON WITHOUT WRITTEN PERMISSION FROM
 DART AEROSPACE LTD.

E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
DESIGN	DS	DRAWN BY PH
CHECKED	PH	APPROVED
DATE	05.07.13	DRAWING NO. D2574
		TITLE INNER AFT SADDLE
		REV. E SHEET 1 OF 1 SCALE 2:3

DART

DART AEROSPACE LTD.
WINDSOR, ONTARIO, CANADA

